

Date: Thursday, 7/19/2007 2:25:38 PM  
 User: Kim Johnston

## Process Sheet

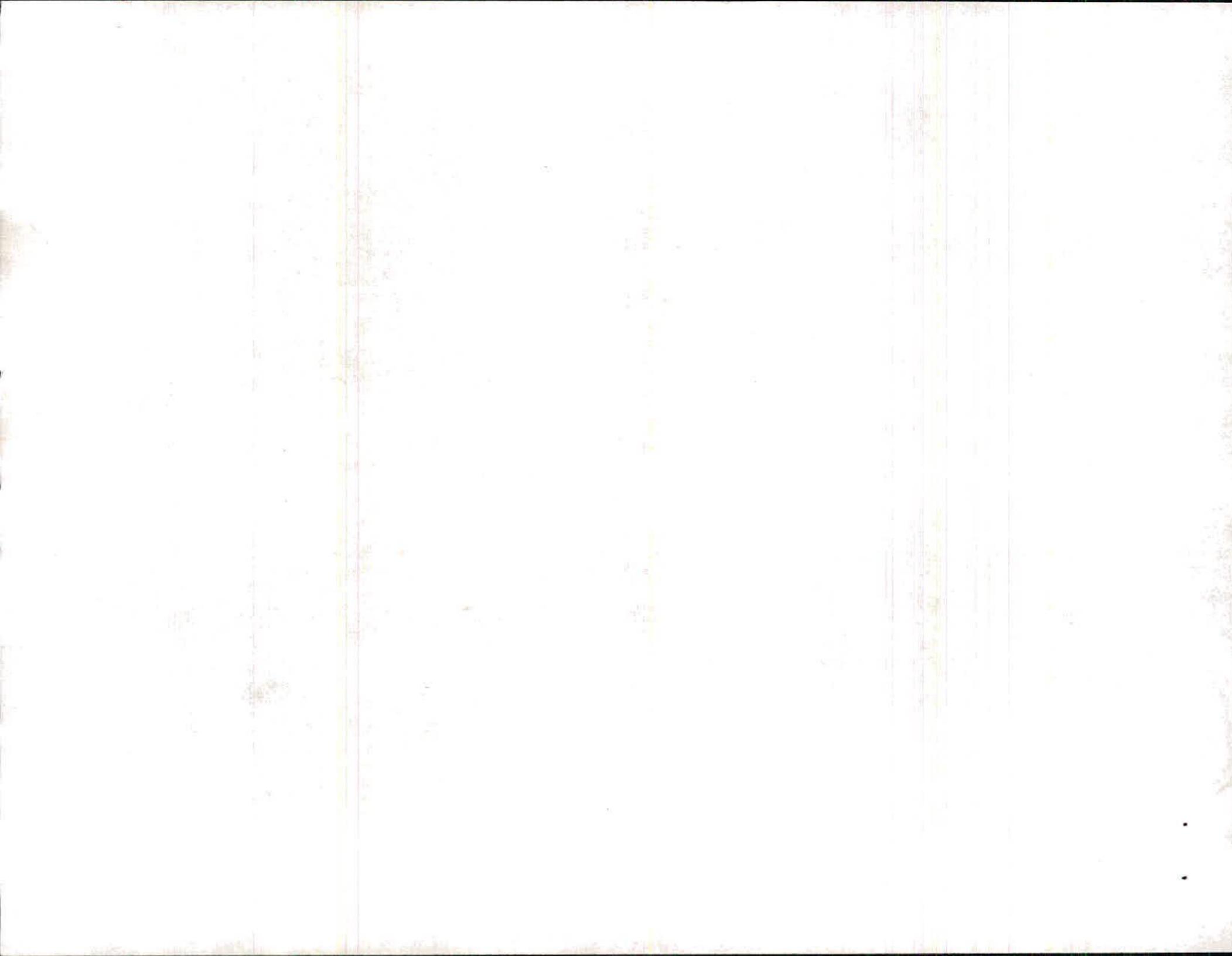
Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	WEARPAD		
Job Number	33660 <i>X2</i>			Part Number	D35371		
Estimate Number	12712			Drawing Number	D3537 REV C		
P.O. Number				Project Number	N/A		
This Issue	7/19/2007 S.O. No. :			Drawing Revision	C		
Prsh Rev.	NC			Material			
First Issue	11 Type : SMALL /MED FAB			Due Date	7/31/2007		
Previous Run	33284			Qty:	80		
Written By	<i>JL</i> 07.07.19			Um:	Each		
Checked & Approved By							
Comment:	Est Rev:A New Issue: 07-02-14 JLM						

Additional Product

Job Number



Seq. #	Machine Or Operation:	Description:	
10	M304S16GA	304/316 063 Sheet	
		Comment: Qty.: 0.0788 sf(s)/Unit Total: 6.3000 sf(s) M304S16GA .063" 304 SS SHEET Batch: <i>M105061</i>	<i>SAD 07/07/20</i>
20	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <i>C</i> Prog Rev: <i>C</i>	
		2-Deburr if necessary	<i>SAD 07/07/20</i>
30	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SAD 07/07/20</i>
40	QC6	SECOND CHECK	
		Comment: SECOND CHECK	<i>SP 07/07/20</i>
50	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1	<i>FF 07-07-31</i>



# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33660

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty

Description

Batch

A/R 2059B Hardcoat

M105258 / M105138

SL 07/08/12

58x

1-Weld as per Dwg D35371 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

SL 07/08/02

5

7.0

QC9

VISUAL WELDING INSPECTION



(58)



Comment: VISUAL WELDING INSPECTION

Mo7/08/13

~~Mo7/08/13~~

8.0

QC5

INSPECT WORK TO CURRENT STEP



(58)



Comment: INSPECT WORK TO CURRENT STEP

Mo7/08/13

9.0

POWDER COATING

POWDER COATING



M 104846

58x

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BL/m-f 07/08/13

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(58)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 07/08/13

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

FZ 07/08/13 (58)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



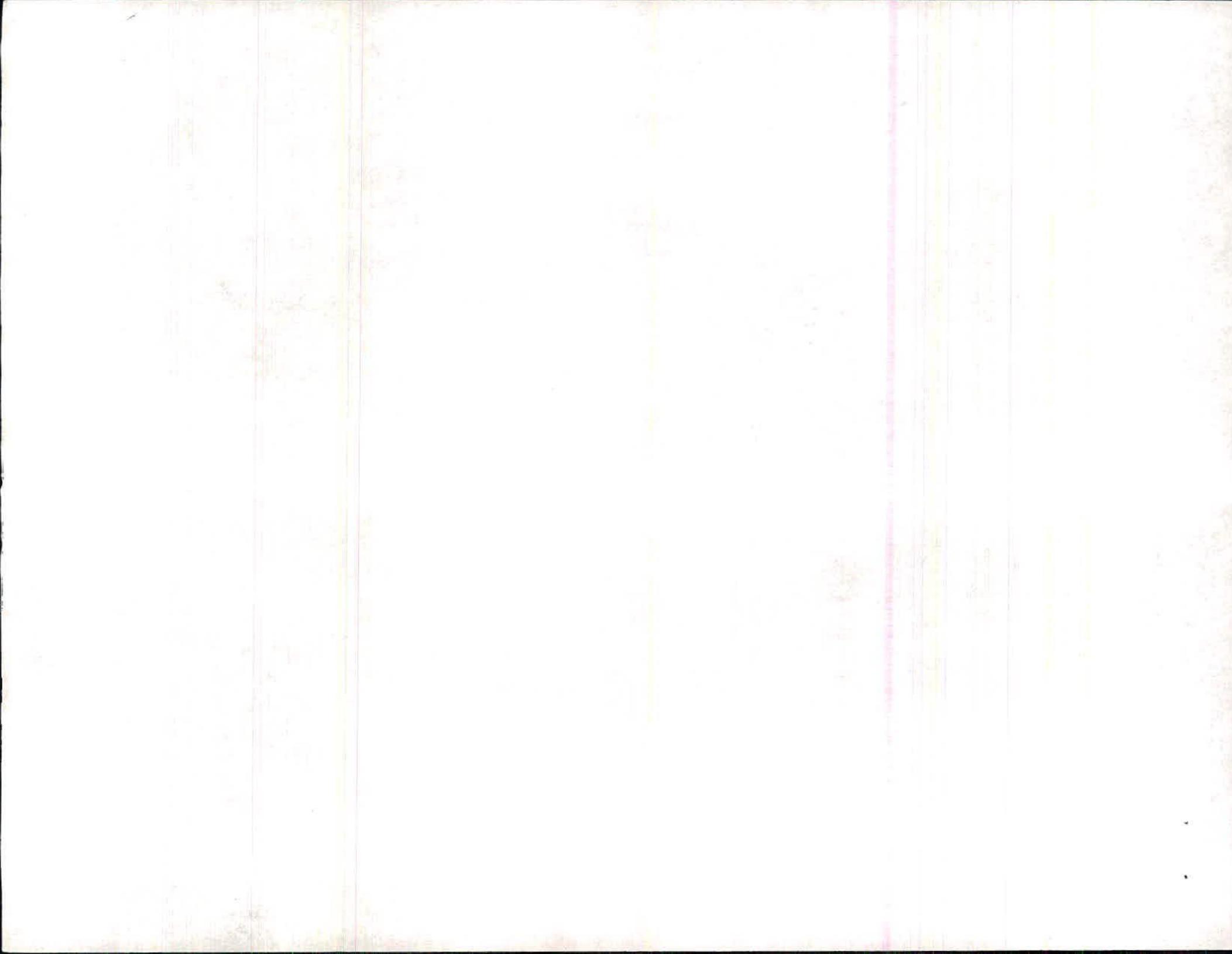
Comment: FINAL INSPECTION/W/O RELEASE

Mo7/08/14

Job Completion



C 07/08/14



DART AEROSPACE LTD	Work Order:	33660
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

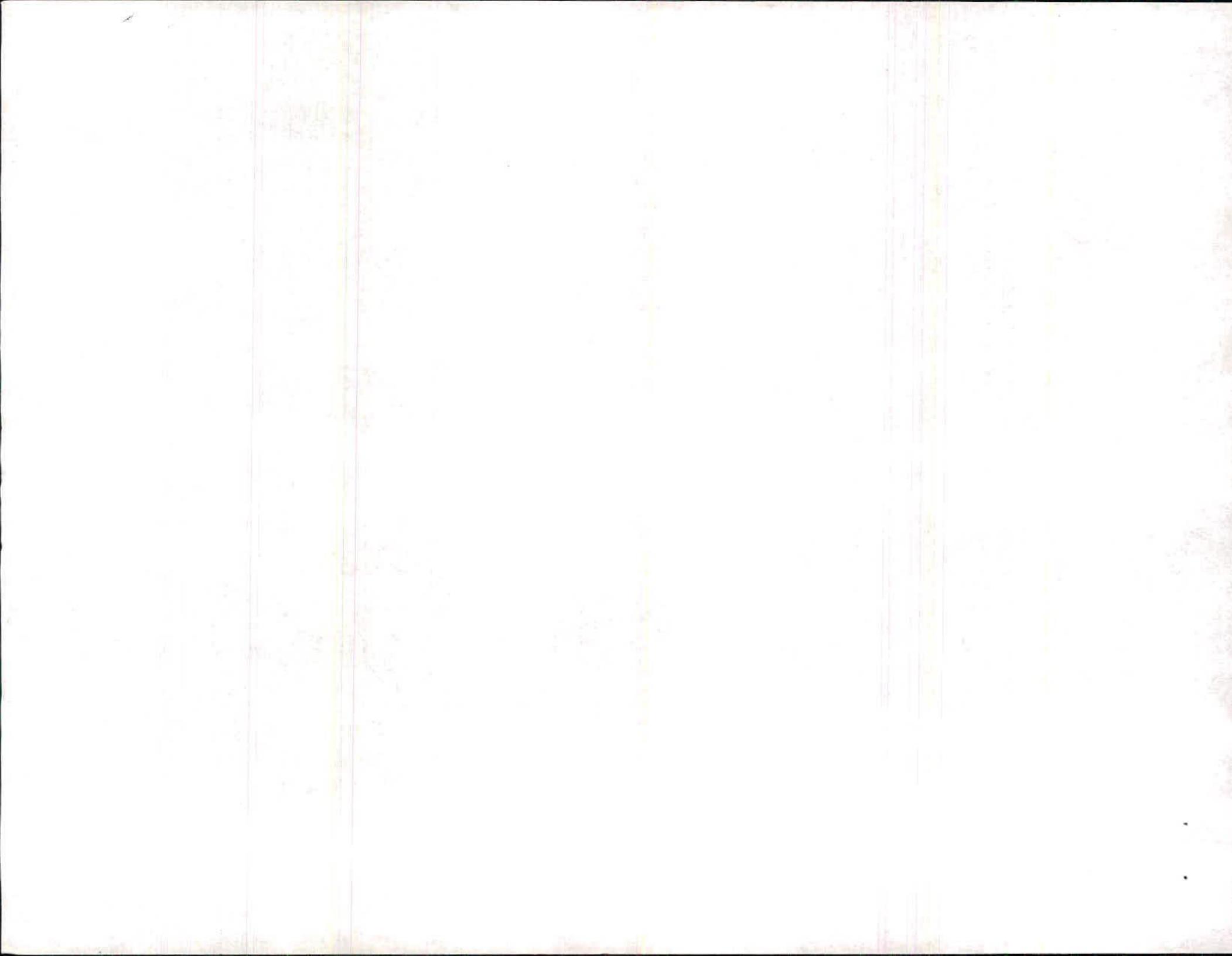
## X First Article      Prototype

Measured by: SAD  
Date: 07/07/20

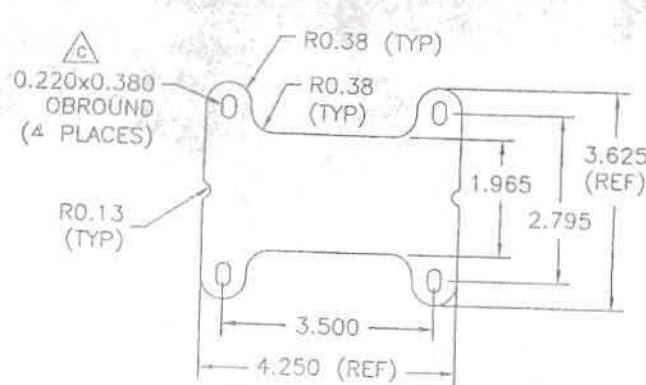
Audited by:	S
Date:	04/07/23

Prototype Approval:	N/A
Date:	N/A

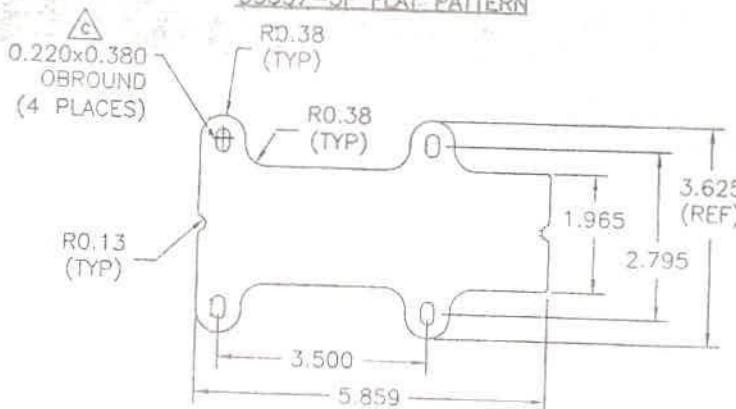
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	JL



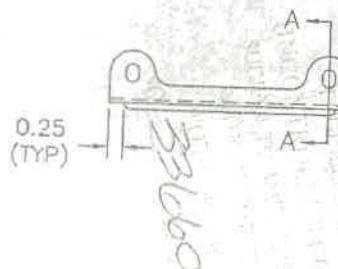
D3537 1C FLAT PATTERN



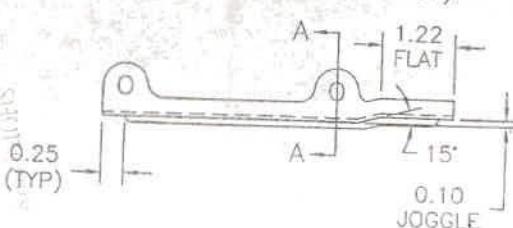
D3537-3F FLAT PATTERN



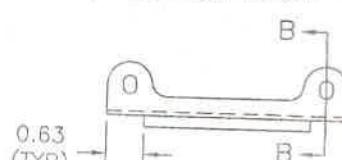
D3537-1 LONGITUDINAL BEND  
(MADE FROM D3537-1E)



D3537-3 LONGITUDINAL BEND  
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND  
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)

2) BREAK ALL SHARP CORNERS 0.063 MAX.

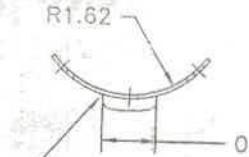
3) WELD PER QSI 004

4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

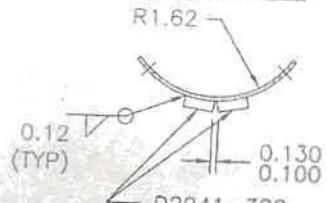
6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS.  
0.188 TO 0.250 THICK

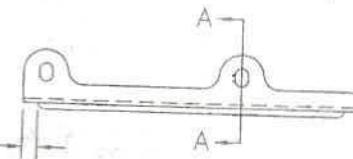
SECTION B-B



D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

RELEASER  
03.05.08 AH

D3537-7 LONGITUDINAL BEN  
(MADE FROM D3537-3F)



		A	06.11.06	NEW ISSUE	DART AEROSPACE USA, INC. PORT HADLOCK, MA	
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		DATE 07.04.13		TITLE WEARPAD	SHEET 1 OF 1	

